

Work Order ID 81495

81495

Page 1

March-14-12 4:23:17 PM

Item ID: D3211-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 14/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 28/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: MCV

Date: 12/03/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3211	B					9			

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3211 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

2024 1063

B12-5-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-30

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

9

M 12.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3211-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 14/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 28/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140		0.00							
140	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Bend D3211-1 Stack as per Dwg D3211								
150		0.00							
150	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

N/A

Sb

12/06/28

8.7/00/25

89

W/O:		WORK ORDER CHANGES					
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 Required Date: 28/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00				9	MA	12/6/3	
Hand Finishing									

170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:20 OVEN TEMPERATURE:								
	FINISH TIME: 3200F 9:50								

m. 21279

180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

MA 12/07/03

9 20/12 12/07/03

W/O:		WORK ORDER CHANGES					
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 Required Date: 28/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>211</u>	0.00							
190									
Packaging	Memo	0.00				<u>9</u>			<u>12/07/04 JB</u>
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							<u>12/7/5</u>
Quality Control									

umf
12-07-04

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-14-12 4:23:20 PM

Page 1

Work Order ID: 81495

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Parent Item: D3211-1

D3211-1

Parent Item Name: Bracket

Start Date: 14/03/2012

Required Date: 28/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A

New Issue 05-11-17 JLM

IPP Rev:B

Now on Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

171.9000

1.405

11.83158

26.

M2024T3S 063

**

B12-5-30

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

171.9

119916

171.9

121197

9

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Dart Aerospace Ltd

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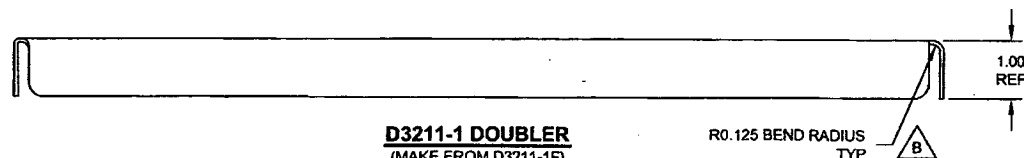
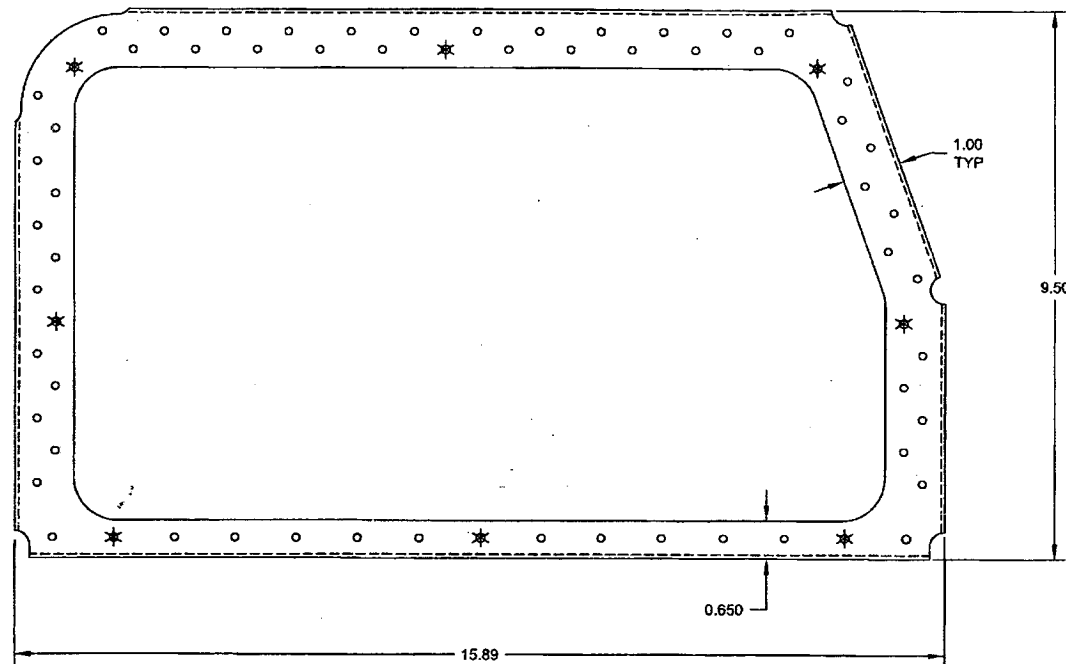
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81495 MLJ
12/03/14

RELEASED
2011-06-14



D3211-1 DOUBLER
(MAKE FROM D3211-1F)
(D3211-1B SIMILAR, MAKE FROM D3211-1BF)

D3211-1/-1B NOTES:

- 1) MATERIAL: MAKE FROM D3211-1F OR D3211-1BF AS APPLICABLE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.49 lbs

B	FORMAT TO NEW STD; INCORP. REV. A1 AND DEO: ADDED D3211-1/-1BF. REASON: PAR11-109.	MB	11.06.06
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV: B
MFG. APPR.		D3211	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.06.06	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ANY DISSEMINATION OF THIS DOCUMENT WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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81495

RELEASED
2011-06-10

D3211-1F FLAT PATTERN

D3211-1F NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs
- 8) MAKE FROM D3211-1F_REV.B.DXF AND CHECK PER D3211-1T1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3211	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.06.06	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

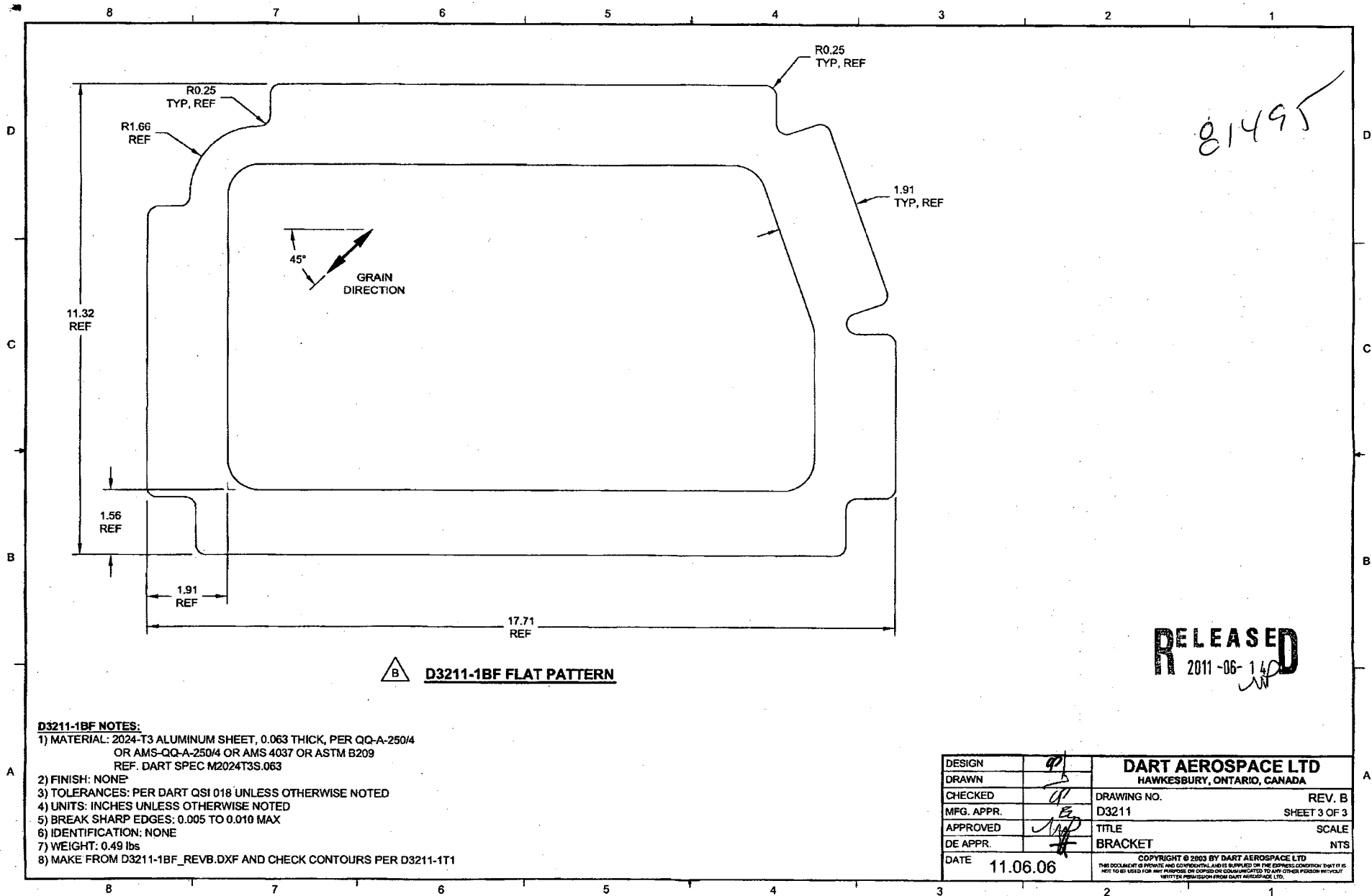
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